



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3269-2**Job Sheet 194157****Part No:** D3269-2**Job Qty:** 4 pcs**Part Name:** Bubble Window - RH**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/25/19**Job Tracking No:****Due Date:** 6/10/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV E IPP A 05.03.22 New issue KJ/JLM IPP B 05.05.09 Added engraving EC IPP Rev:06-07-03 As per Rev C JLM IPP C 07.11.06 Thermoform in-house DL verified by:EC IPP Rev: D 08.07.24 As per New Tool DL. IPP Rev E 14/01/20 Replace "Folio" with Work Instruction DL

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	4 pcs	6/10/19	6/10/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
140	Packaging 2-1 - Receive - B4B	4 pcs	6/10/19	6/10/19	0.00	0.00	Packaging 2 - 1 - B4B		DP JUN 07 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		DP JUN 07 2019
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		

**Container No:** S188517**Part:** D3269-2**Job No:** 194157**Serial No/Batch:** S188517**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/07/19

Plex 6/7/19 8:43 AM dart.Lussier.Patrick

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
150 QC 6	4 pcs	6/10/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	JUN 07 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
170 Packaging 3-1 - Stock - B4B	4 pcs	6/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	2-28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS
				Packaging 3 - 36 - B4B	21
180 QC 21 - SA	4 pcs	6/10/19	0.00 0.00	QC 21 - SA - 21	9-89
				QC 21 - SA - 70	JUN 10 2019
				QC 21 - SA - 53	

Part Op 110 - (Purchasing) ISSUE P/O: HB043306 SUPPLIER: PLASTECB MANUFACTURE D3269-2 AS PER
 Descriptions: DWG C OF C IS REQUIRED
 140 - (Receive & Inspect for Damage & Mat'l Certs)
 150 - (QC6- All purchased or subcontracted products)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

x4 Rls

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3269-2P	Bubble Window - RH	4 pcs (1 ea)	110-Purchasing	5188S14
MACRYLICS.177	0.177" Plexiglas G Clear Cast Acrylic Sheet	64 sf (16 ea)	110-Purchasing	506A67

Job Allocations

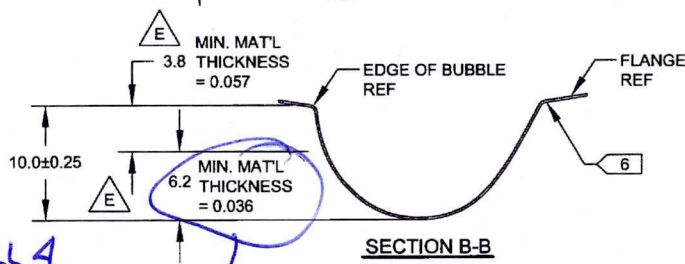
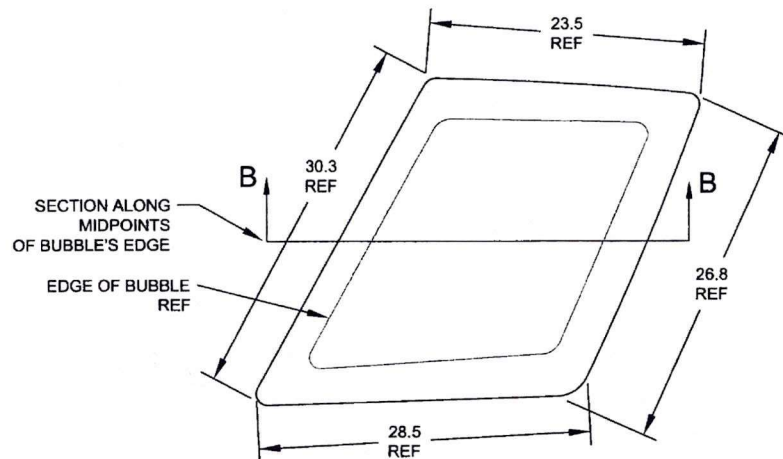
Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D3269-2P	4	0	0
	MACRYLICS.177	64	1,531	0

Part Specifications

Specifications could not be found.

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8 7 6 5 4 3 2 1



MIN-ALL 4
0.054"

D3269-2 BUBBLE WINDOW, RH

NOTES

- 1) MATERIAL: PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 0.177 TO 0.188 THICK (STOCK, REF DART SPEC M-ACRYLIC-S)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: ENGRAVE P/N & B/N ON FLANGE WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX DEPTH OF 0.005".
 - 7) WEIGHT: 4.88 lbs
 - 8) FORM PER D3269-2T1 AND QSI 022
- FORMING PROCESS: (a) DRAPE OVER D3269-2T1 MOLD
(b) HEAT TO 290°F
(c) VACUUM FORM TO SPECIFIED HEIGHT
(d) LET COOL TO AT LEAST 100°F BEFORE HANDLING
(e) TRIM FLANGE TO PROFILE OF MOLD

JUN 17 2019

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194157 MLS
1904-25

RELEASED
2009-09-23

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. E
MFG. APPR.	MF	D3269	SHEET 2 OF 2
APPROVED	MF	TITLE	SCALE
DE APPR.	MF	BUBBLE WINDOW	NTS
DATE	09.08.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043306



Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: POHB043306

PO Date: 4/25/19

Due Date: 6/6/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

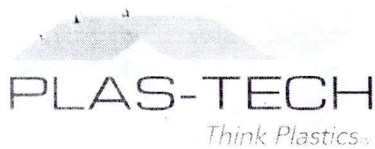
Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194157	D3269-2P			Bubble Window - RH : Various STC's	Firmed X4	-	6/6/19	4 pcs	0 pcs	4 pcs	\$582.50/pcs	\$2,330.00
JUN 07 2019													
DP													
68 9-89													
Grand Total:													
\$2,330.00													



115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM
P- 416 736 0004
F- 416 736 0010

Packing Slip

Shipment Number: 36081
Shipment Date: 06/04/2019
BOL Number:
Customer Key: C1887
Salesperson: MIKE AUBE
Page Number: 1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: DALE BATES
O Buyer Contact: PATRICK LUSSIER

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: PATRICK LUSSIER
O

Purchase Order
HB043306
Carrier Account #
CU103666

Sales Order
SO-028629

Incoterms
EX WORKS

Payment Method
COL
Tracking Number

Ship Via
JOURNEY FREIGHT -

Item Number
Revision

Description

Quantity
Shipped

UOM

D3269-2P - Rev.: E

BUBBLE WINDOW, RH, R44

4

EA

AS PER DWG D3269

RECEIVED

JUN 06 2019

DART AEROSPACE LTD.

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # HB043306 SO # 028629

Part #	<u>D3269-2P</u>	Qty.	<u>4</u>	Batch #	<u>-001</u>
Description	<u>BUBBLE WINDOW, RH, R44</u>	Material usage	<u>64 SQ. FT.</u>	Lot#	<u>DART0114</u> <u>S061167</u> <u>DAS 68 2.89</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: 
(Approved QA Signatory)

Date: JUNE 5, 2019 C OF C # 120

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

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